

Thursday, 3/30/2006 10:06:20 AM

User: Kim Johnston

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP SPACER  
 Job Number : 26452D -2  
 Estimate Number : 10380  
 P.O. Number : N/A Part Number : D30657  
 This Issue : 3/30/2006 S.O. No. : N/A Drawing Number : D3065 REV. A2  
 Print Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A2  
 Previous Part : 26211D Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 4/15/2006 Qty: ~~60~~ to 3 Um: Each  
 Checked & Approved By : 06.23.30  
 Comment : Est: C 02:11:01 Incorporated D3066-1 IPP KJ/RF

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty: 0.1653 sf(s)/Unit Total: 9.9162 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 0119295

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 4.580" x 4.500" Grain along 4.500"

3.0

HAAS

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA181 and Dwg D3065

Stack of 15

Identify as D3065-7

Dwg Rev: A2Prog Rev: A2

06 04 27 (60)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 04 27 (60)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06 04 27 (50)

# Process Sheet

Customer: RU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26452D

Part Number: D30657



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr Stack

M.F. 06.05.01

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Bend as per Dwg D3065

SB 06/05/01 (3)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06.05.01 (3)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M.F. 06.05.01

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/05/01 (3)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: GA

SB 06/05/01 (3)

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

SB 06/05/01 (3)

Job Completion



U 06.05.02